Work Orden December 19-12				*945	597*						Page 1
Item ID: Revision ID: Item Name:	D4021-1 Handle Plate			Accept	*N900	040	100	)* s	etup Star Stop	1/1	S1* S2*
Start Date: Required Date: Reference:	12/24/12: 1/11/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	ID:					
Approvals:		n:	Date: <u>3-01-2</u>			ate:		R	un Star Stop	" <b>[V</b> ]	R1* R2*
Sequence ID/ Work Center I		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr									
D4021	В										
*100 *100* Waterjet FLOW CNC Waterj 304 . 125	•	Memo Cut as per e Prog Rev:_ Dwg Rev:_	8	0.00				4	_0_		<u>In 1-6</u> -13
*110 *110*		Deburr as r QC2- Inspect parts off r		0.00				4_			<u>Jm 1-</u> 6-13

Memo

Quality Control

											DQA:	Date	:
NCR:	es/	/ No				WORK ORDER NON-O	100	NFORM	<b>JANCE / UPDA</b>	<b>NTE</b>			
									-		QA Closed:	Date	:
Work Orde	r.					DISPOSITION							
Part No.						Rework Scrap Use-as-is		Skid-tube Crosstube Small Fab Thermoforming Finishing				Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	۱o. <sub>-</sub>					Work Order Update	]		~ <del></del>	Composite		Supplier	
Root		<del>- : </del>			Descri	ption of work order update	Ī	nitial	Action	n	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Descript	tion	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling										·	i		
Operator													
Material													
Setup													1
Other				:				:					
Process													ļ
Supplier													
Training													
Unapproved													<u> </u>
						F	AUI	T CATE	GORY				
Landi	ng G	iear			•	General		_			_	_	
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	ct	Weld
:		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/Und	clear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved	•	
		Heat Trea	t			Countersink		Mislabe	eled	-	Positioned \	Vrong	
!	П	Inspection	n Strip in	Tube		Cut Too Short		Misread	į		Power Loss,	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Work Order ID 94597 \*94597\* Page 2 December-19-12 1:03:57 PM D4021-1 Accept \*N900040100\* Item ID: Setup Start **Revision ID:** Handle Plate Item Name: Start Qty: 4.00 **Start Date:** 12/24/12 **Cust Item ID:** Required Date: 1/11/13 Req'd Qty: 4.00 **Customer:** Reference: Run Start Process Plan: Date: Tooling: Date: **Approvals:** Stop **SPC (Y/N):** Date: \_\_\_\_\_ QC: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Code Qty Qty Number Stamp Description **Run Hours** 120 QC8- Inspect parts - second check 0.00 Smb \*120\* 0.00 13 1-1 QC Memo Quality Control Identify as per dwg & Stock Location: WHOO 4 140 (p(13.1.7 \*140\* 0.00 Packaging Memo Packaging

0.00

0.00

150

QC

\*150\*

Quality Control

QC21- Final Inspection - Work Order Release

Memo

ML5 13-07-07

NCR:	⁄es	/ No				WORK ORDER NON-C	O	NFORM	AANCE / UPI	DATE	QA Closed:	Date	
Work Orde	er:					DISPOSITION			<u> </u>	AGAINST DE			
Part No.  NCR No.						Rework Skid-tube Crosstube  Scrap Machining Small Fab  Use-as-is Thermoforming Finishing  Work Order Update Large Fab Composite			Small Fab Finishing	i	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other	
Root Cause		Date	Step	Qty		ption of work order update	ł	nitial ief Eng		tion ription	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
						F	AUL	T CATE	GORY		,		
Landi		Gear Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at n Strip in Bend	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/U enance eled	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	et ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

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December-19-12 1:03:57 PM

Work Order ID:

94597

Parent Item:

D4021-1

Parent Item Name:

Handle Plate

**Start Date:** 12/24/12

Required Date: 1/11/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M304S11GA		Purchased	No			100	sf	104.5000	0.1225	Q.5157896			<u> </u>	
304/316 0.125 Sheet										0.6			m 1-6-	1

Location	Loc Qty	Loc Code	
MAT020	104.5		
122521	104.5		122521

											DC	(Α: _	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	<b>VFORM</b>	MANCE / UP	DATE		_		
								•			QA Close	ed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTME	NT/	PROCESS	
Part No.  NCR No.						Rework Skid-tube Machining Use-as-is Thermoforming Large Fab		Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other		
												<del></del> -		1
Root	- 1	_	_		i '	ption of work order update	•	Initial		tion	Sign &			
Cause	.	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription	Date	-	Verification	QC Inspector
Doc/Data	Щ											- 1		
Equip/Tooling	Щ											ı		
Operator	Ш											Ì		
Material	Н													
Setup	Ш				 	·								
Other	Н											Ì		-
Process	Щ													
Supplier	Ш						1							
Training	Ш										1			
Unapproved					<u> </u>		<u> </u>							
							AUL	T CATE	GORY					·
Landi	_					General		7			1		_	¬ ·
	$\boldsymbol{\vdash}$	Bending			_	Bend	<u>_</u>	Grain			Ovalized		<u> </u>	Pressure/Forced
	Ш	Centre No	t Concer	itric to	o/s	BOM/Route	<u></u>	Hardwa	ire		Over/Un	der 1	tolerance	Temperature/Cure
	Ш	Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Inco	rrec	t	Weld
	Ш	Crushed/0	Crimped,			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost	/Mis	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Mov	ved		
	Ш	Heat Trea	t			Countersink		Mislabe	eled		Position	ed W	/rong	_
		Inspection	Strip in	Tube		Cut Too Short		Misread	d	<u> </u>	Power Lo	oss/S	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish .

Folio

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DART AEROSPACE LTD	Work Order:	94596
Description: Handle Plate	Part Number:	D4021-1
Inspection Dwg: D4021 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.13	+/-0.030	5.133	·		V	JEMOI
0.75	+/-0.030	0.758"	-		ν	
2.25	+/-0.030	2.257"	_		V	
0.75	+/-0.030	0.758"	_		Ų	
0.125	+/-0.010	Ö. 113"			Ů	
			<u> </u>			
						ļ
					·	

Measured by:	Im	Audited by: SMD	Preliminary Approval:
Date:	/ /2	Date: 12-1-7	Date:
Date.	1-0-13	73/	

Rev Date Change Revised 9y	Approved
RevDateChangeRevised byA10.06.08New IssueKJ	A

